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D3488-3**Job Sheet 194947****Part No:** D3488-3**Job Qty:** 12 pcs**Part Name:** Blade Fitting, LH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 5/10/19**Job Tracking No:****Due Date:** 5/24/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs		5/24/19	0.00	10.55	Doosan - 1		JSD 14/05/28
110	QC 2	12 pcs		5/24/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 HAAS 4 Axis - B4B	12 pcs	5/24/19	0.11 8.23	QC 2 - 65	JSD 19/05/24
				QC 2 - 5	
				QC 2 - 71	
				HAAS - 1 - B4B	
				HAAS - 2 - B4B	Kt 19.07.13
130 QC 2	12 pcs	5/24/19	0.00 0.00	HAAS - 3 - B4B	
				HAAS - 4 - B4B	
				QC 2 - 1	
				QC 2 - 12	Kt 19.07.13
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
140 QC 8	12 pcs	5/24/19	0.00 0.00	QC 8 - 12	mmL 19/07/14
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	

150 Handfinish - 1-1 Chemical-B4B	12 pcs	5/24/19	0.00 0.35	QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	JUL 15 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White Gl(A)-B4B	12 pcs	5/24/19	0.00 0.42	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	12 pcs	5/24/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	

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					QC 3 - 41						
					QC 3 - 51						
					QC 3 - 58						
					QC 3 - 59						
					QC 3 - 68						
					QC 3 - 9						
					QC 3 - 40						
					QC 3 - 19						
					QC 3 - 43						
					QC 3 - 24						
					200 Packaging 3-1 - Stock - B4B	12 pcs	5/24/19	0.00	0.00	Packaging 3 - 1 - B4B	
										Packaging 3 - 2 - B4B	
Packaging 3 - 3 - B4B											
Packaging 3 - 4 - B4B											
Packaging 3 - 5 - B4B											
Packaging 3 - 6 - B4B											
Packaging 3 - 7 - B4B											
Packaging 3 - 8 - B4B											
Packaging 3 - 9 - B4B											
Packaging 3 - 10 - B4B											
Packaging 3 - 11 - B4B											
Packaging 3 - 12 - B4B											
Packaging 3 - 13 - B4B											
Packaging 3 - 14 - B4B											
Packaging 3 - 15 - B4B	FP-001 9/14-7-15										
Packaging 3 - 16 - B4B											
Packaging 3 - 17 - B4B											
Packaging 3 - 18 - B4B											
Packaging 3 - 19 - B4B											
Packaging 3 - 20 - B4B											
Packaging 3 - 21 - B4B											
Packaging 3 - 22 - B4B											
Packaging 3 - 23 - B4B											
Packaging 3 - 24 - B4B											
Packaging 3 - 25 - B4B											
Packaging 3 - 26 - B4B											
Packaging 3 - 27 - B4B											
Packaging 3 - 28 - B4B											
Packaging 3 - 29 - B4B											
Packaging 3 - 30 - B4B											
Packaging 3 - 31 - B4B											

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					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	12 pcs	5/24/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	JUL 16 2019
					QC 21 - SA - 53	

Part Op 100 - 1-Turn as per Dwg DSK 101 & Folio FC491

Descriptions: 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)

120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488

130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)

140 - QC8 Machining-2 (QC8- Inspect parts - second check)

150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

170 - QC3 (QC3- Inspect Part Finish)

200 - Packaging3-1 (Identify as per dwg & Stock Location: _____ LOCATION : FP001)

210 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6103-003	Round Billet, Aluminum	12 pcs (1 ea)	100-Doosan - 1	557287 5192446

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	D6103-003	12	17	0

Part Specifications	
Specifications could not be found.	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S184950



Part: D3488-3

Job No: 194947

Serial No/Batch: S184950

Revision: D/C

Inspector:

Exp Date:

Instructions:

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/29/19

DART AEROSPACE LTD	Work Order: 194947
Description: Blade Fitting, RH / Turning Detail for D3488-3	Part Number: D3488-3
Inspection Dwg: D3488 / DSK101 Rev: C / D	Page 2 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	0.508	✓		Kt-05	verm.
0.750	+/-0.010	0.750	✓		31006	H-G
1.500	+/-0.010	1.500	✓		Kt-05	verm.
11.18	+/-0.030	11.182	✓		31006	H-G
R0.062	+/-0.010	0.0625	✓		—	R-G
0.125	+/-0.010	0.125	✓		Kt-05	verm.
0.590	+/-0.010	0.590	✓		—	—
0.793	+/-0.010	0.793	✓		Kt-05	verm.
1.351	+/-0.010	1.351	✓		31006	H-G
1.317	+/-0.010	1.317	✓		Kt-05	verm.
1.802	+/-0.010	1.802	✓		31006	H-G

Measured by: L. J. B. D.	Checked by: M. M. C.	QC Inspector:
Date: 19-07-13	Date: 19/07/14	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	19.06.14	New Issue	MG	